

Date: Wednesday, 26/11/2008 12:46:48 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 43772	
Estimate Number : 12951	
P.O. Number :	Part Number : D32593
This Issue : 26/11/2008 S.O. No. :	Drawing Number : D3259 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 34251	Material :
Written By :	Due Date : 03/12/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JLD 08.11.26</u>	
Comment : Est Rev:A New Issue 07-07-19 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 1.4574 sf(s)/Unit Total : 5.8296 sf(s)
 2024-T3 .063 sheet
 Batch: 106223 B 8-10-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3259
 Dwg Rev: A1
 Prog Rev: A1

B 8-10-9

2-Deburr if necessary B 8-10-9

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 8-10-9**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKS 08/12/09 (S)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-C'Sink Holes as per Dwg D3259

09/01/14 (S)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:46:48 PM
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Drawing Name: DOUBLER

Job Number: 43772

Part Number: D32593

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D3259

SB 09/01/18 (5)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/18 (5)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AD 09-01-20 (KS)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 09/01/20 (5)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST181

SS 09/01/20 (KS)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/21

Job Completion



W And, 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43772
Description: Doubler		Part Number: D3259-3/-4
Inspection Dwg: D3259	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

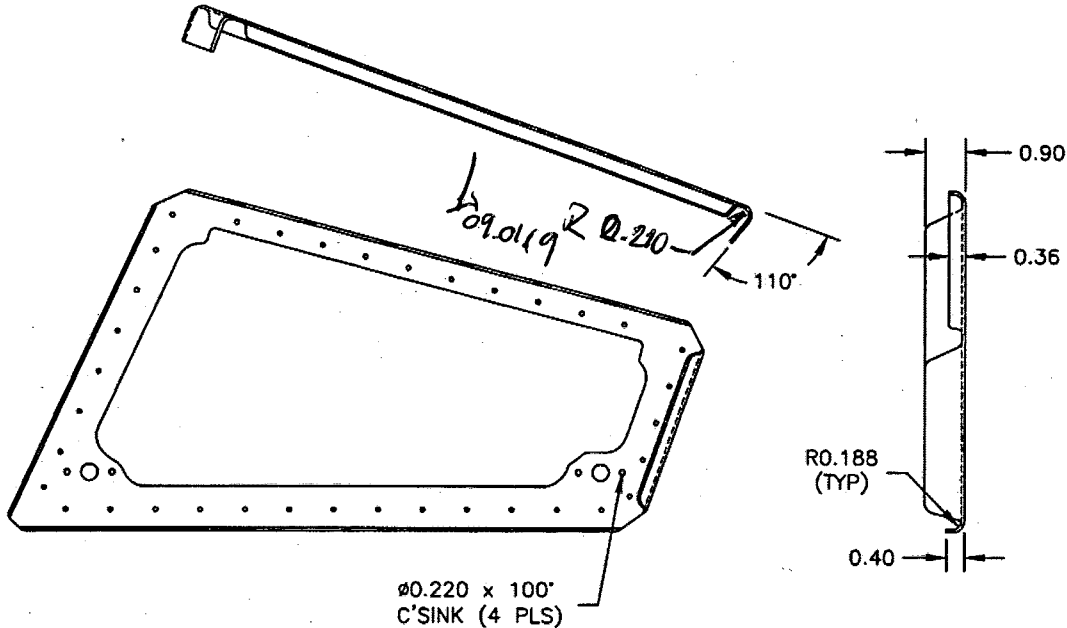
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.062	+/-0.010	10.066	X			
9.000	+/-0.005	8.994	X			
1.000	+/-0.005	.998	X			
0.260	+/-0.010	.258	X			
0.900	+/-0.010	.899	X			
R0.25	+/-0.030	.25	X			
R0.50	+/-0.030	.50	X			
5.000	+/-0.005	5.002	X			
0.875	+/-0.005	.875	X			
1.300	+/-0.010	1.305	X			
12.000	+/-0.005	11.998	X			
3.500	+/-0.005	3.495	X			
0.875	+/-0.005	.876	X			
R0.13	+/-0.030	.13	X			
0.500	+/-0.005	.501	X			
0.525	+/-0.005	.527	X			
1.80	+/-0.030	1.798	X			
Ø0.128	+0.005/-0.000	.130	X			
Ø0.377	+0.005/-0.000	.381	X			
Ø0.098	+0.005/-0.000	.102	X			
0.063 thick	+/-0.005	.061	X			
Grain Direction	N/A		X			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 8-12-9	Date: 08/12/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	

DART

DESIGN DT	DRAWN BY DT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3259	REV. A SHEET 3 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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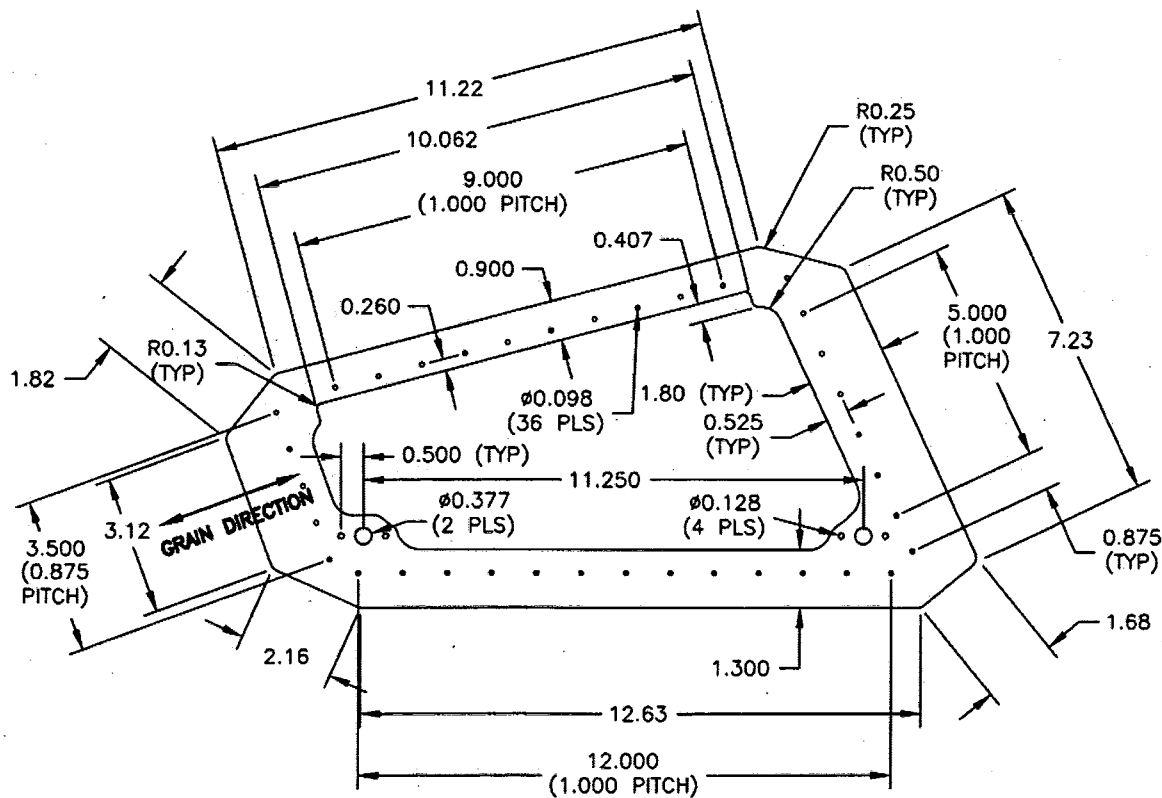
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3259	REV. A SHEET 4 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14 [Signature]



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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